

Date: Monday, 6/12/2006 3:36:33 PM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	HI-SKI STEP LEG		
Job Number	27501		Part Number	D2499		
Estimate Number	11833		Drawing Number	D2499 REV B		
P.O. Number	N/A		Project Number	N/A		
This Issue	6/12/2006 S.O. No. N/A		Drawing Revision	B		
Prsht Rev.	NC		Material	N/A		
First Issue	N/A		Type	MACHINED PARTS		
Previous Run	N/A		Due Date	7/15/2006		
Written By	<i>S.F. Comment Below</i>		Qty:	12 Um: Each		
Checked & Approved By	<i>S.F. 06.06.13</i>		Comment			
Comment	Est. A006.26 Removed P/O for powder coat		EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :				
1.0	M6061T6B1000X04000	6061-T6 Bar 1.0" x 4.0"				<i>J.F. 06/06/23 12</i>
		Comment: Qty.: 1.9906 f(s)/Unit Total : 23.8871 f(s) 6061-T6 Bar 1.0" x 4.0" 6061-T6 1.00" Thick Batch <i>M12315</i>				
2.0	BAND SAW	BAND SAW				<i>J.F. 06/06/23 12</i>
		Comment: BAND SAW Cut blanks: 8.500" x 4.000"				
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1				<i>J.F. 06/06/23 12</i>
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2499 Deburr				
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE				<i>mf 06/06/24 12</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE				
5.0	QC8	SECOND CHECK				<i>J.F. 06/06/24 12</i>
		Comment: SECOND CHECK				
6.0	POWDER COATING	POWDER COATING				<i>Ep 06/06/26 2</i>
		Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06/06/27	6	Alodine before powdercoat. permanent change. 2				J.W.	2
							06/06/27

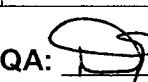
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

No DQA: 

Date: 06/06/27

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-SKI STEP LEG

Job Number: 27501

Part Number: D2499

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



M 06 06 27 12

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: S177

106/06/27 12

9.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

106/06/27 12

Job Completion



106/06/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

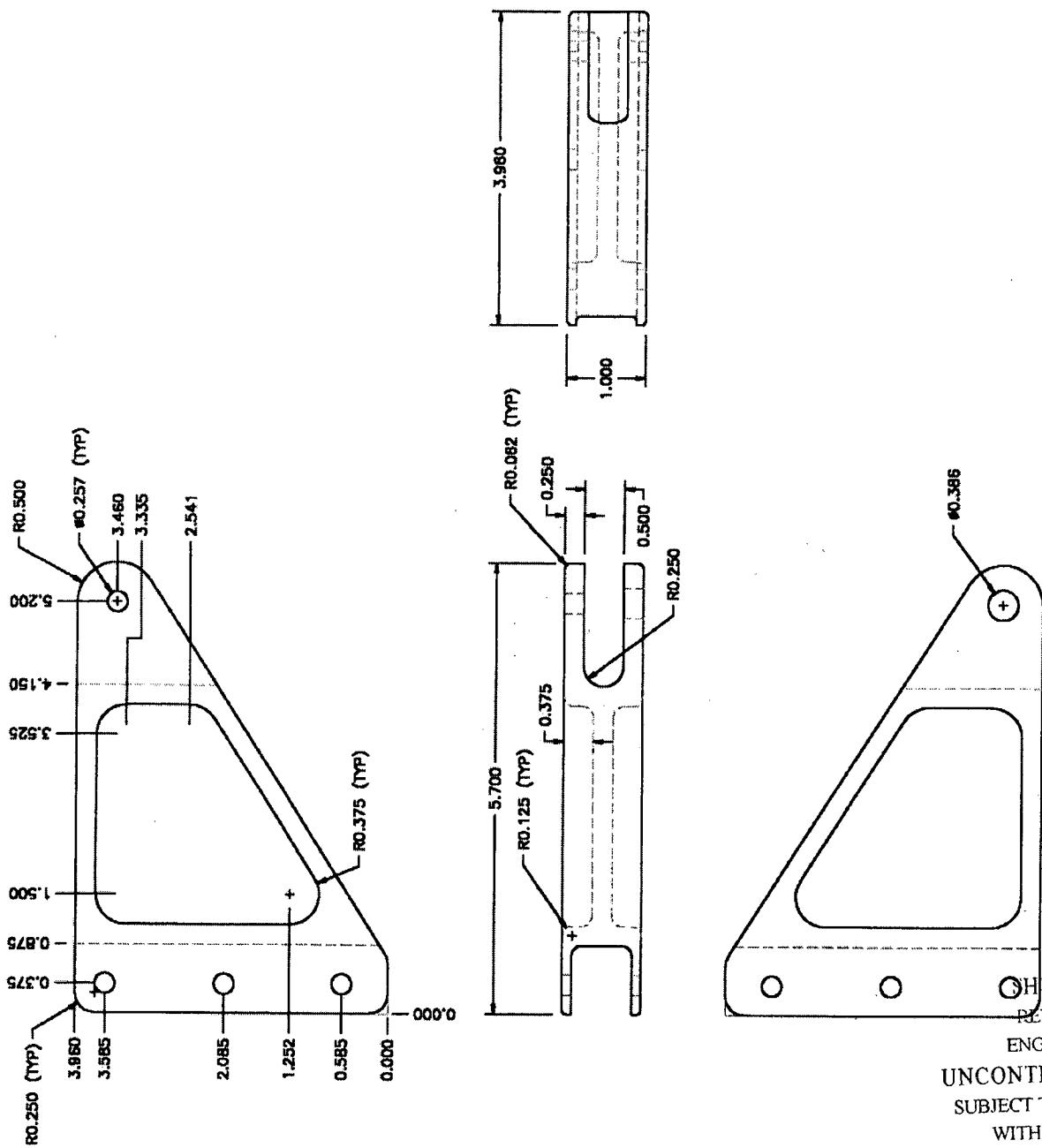
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN B. WILLIAMS	DRAWN BY K. HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>B.W.</i>	APPROVED <i>S.S.</i>	DRAWING NO. D2499	REV. B SHEET 1 OF 1
DATE 95:11:09		TITLE MOUNT	SCALE 1:2
B	95.12.06	CHANGE HOLE DIA TO .386	



MATERIAL: 6061-T6

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 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 27501

DART AEROSPACE LTD		Work Order:	27501
Description: MOUNT		Part Number:	D2499
Inspection Dwg: D2499, Rev: B			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article  Prototype

Measured by:	<u>Jill</u>	Audited by:	<u>EJ</u>	Prototype Approval:	<u>N/A</u>
Date:	06/06/24	Date:	06/06/24	Date:	<u>N/A</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	